

Work Order ID 79194

79194

Page 1

January-23-12 1:04:50 PM

Item ID: D2661-2 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Saddle, RH Fwd Aft Out 206
 Start Date: 23/01/2012 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 06/02/2012 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/01/23 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2661	Rev E								

100 0.00 PD 12/02/26 10 0
 100 HAAS CNC VERTICAL MACHINING #1

HAAS 1 Memo 0.00
 HAAS CNC vertical machine #1 Program part number and batch number
 MACHINE AS PER DWG AND FOLIO FB071

FOLIO REV: AA
 DWG REV: E

110 0.00 PD 12/02/26 10 0
 110 CONVENTIONAL MILLING MACHINE

Mill Conv Memo 0.00
 Conventional Milling Machine Machine Keyway and inspect per attached dimension sheet

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 <i>[Signature]</i> 0.00		12/02/26		10	0		
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 <i>OK</i> 0.00		12/02/26		10	0		
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 <i>[Signature]</i> 0.00		<i>NG</i> 28-2-12					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 9:50	OVEN TEMPERATURE:							
	FINISH TIME: 10:20								
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: _____	0.00							
170									
Packaging	Memo PDP 79582	0.00							
Packaging									

10X6 M/L 12/03/02

10 BL 12.3-2

10 12/3/2 (10)

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

MLJ 12/03/05

1203-5
10

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Picklist Print

January-23-12 1:04:54 PM

Page 1

Work Order ID: 79194

79194

Parent Item: D2661-2

D2661-2

Parent Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 23/01/2012

Required Date: 06/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP: C00.11.01Removed P/O for Powder Coat - in house processEC

IPP REV:D

REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD

IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	20.0000	1	10			

D6101-003

Saddle Billet, 7075

B.A. 12/01/29

Location

Loc Qty

Loc Code

MAT040

26

73775

2

73780

7

77562

10

MAT042

-7

MAT044

1

73769

1

→ 78599

10.0

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD				Work Order: 79194	
Description: 206 Saddle, Outboard, Right side				Part Number: D2661-2	
Inspection Dwg: D2661 Rev: E DSK: Rev:				Page 1 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.615	3.615	3.615	3.615	3.615
B	0.256	0.263		0.256	0.256	0.256	0.256	0.256
C	0.315	0.322		0.315	0.315	0.315	0.315	0.315
D	2.495	2.505		2.501	2.501	2.501	2.501	2.501
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		0.123	0.123	0.124	0.123	0.124
H	0.210	0.230		0.222	0.225	0.225	0.228	0.228
I	0.615	0.685		0.685	0.685	0.685	0.685	0.685
J	2.470	2.510		2.493	2.490	2.490	2.490	2.490
K	1.313	1.343		1.322	1.330	1.328	1.327	1.329
L	0.178	0.198		0.188	0.188	0.188	0.188	0.188
M	0.470	0.530		0.500	0.500	0.500	0.500	0.500
N	1.125	1.145		1.135	1.135	1.135	1.135	1.135
O	0.100	0.180		0.140	0.140	0.140	0.140	0.140
P	0.100	0.140		0.130	0.135	0.130	0.135	0.129
Q	0.240	0.260		0.250	0.250	0.250	0.250	0.250
R	0.677	0.697		0.690	0.687	0.683	0.684	0.688
S	0.100	0.140		0.123	0.125	0.120	0.128	0.129
T	1.565	1.585		1.575	1.575	1.575	1.575	1.575
U	0.540	0.560		0.549	0.550	0.553	0.552	0.556
V	0.912	0.932		0.925	0.928	0.928	0.928	0.928
W	0.787	0.807		0.799	0.800	0.797	0.799	0.796
X	5.990	6.010		6.004	6.000	6.006	6.000	6.000
Y	4.995	5.005		4.999	5.000	5.000	5.000	5.000
Z	0.490	0.510		0.506	0.499	0.505	0.506	0.506
AA	0.312	0.319		0.313	0.313	0.313	0.313	0.313
AB	0.990	1.010		1.000	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.249	1.250	1.250	1.250	1.250
AD	0.490	0.510		0.502	0.502	0.504	0.506	0.502
AE	3.745	3.755		3.748	3.750	3.750	3.750	3.750
AF	0.235	0.240		0.237	0.237	0.237	0.237	0.237
AG	0.510	0.515		0.511	0.511	0.511	0.511	0.511
AH	0.100	0.120		0.110	0.110	0.110	0.110	0.110
AI								

W/O:		WORK ORDER CHANGES					
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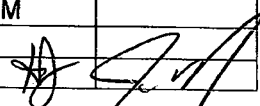
NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	79194
Description: 206 Saddle, Outboard, Right side		Part Number:	D2661-2
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 2 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
AJ								
AK								
AL								
AM								
AN								
Accept/Reject								

Measured by:		Date:	12.03.05
Audited by:		Date:	12/03/05
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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FIRST ARTICLE INSPECTION DIMENSION SHEET

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				1 6	2 7	3 8	4 9	5 10
A	3.611	3.621		3.615	3.615	3.615	3.615	3.615
B	0.256	0.263		0.256	0.256	0.256	0.256	0.256
C	0.315	0.322		0.315	0.315	0.315	0.315	0.315
D	2.495	2.505		2.501	2.501	2.501	2.501	2.501
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		0.124	0.125	0.124	0.125	0.123
H	0.210	0.230		0.228	0.228	0.228	0.228	0.227
I	0.615	0.685		0.685	0.685	0.685	0.685	0.685
J	2.470	2.510		2.490	2.490	2.490	2.490	2.490
K	1.313	1.343		1.328	1.328	1.328	1.328	1.328
L	0.178	0.198		0.188	0.188	0.188	0.188	0.188
M	0.470	0.530		0.500	0.500	0.500	0.500	0.500
N	1.125	1.145		1.135	1.135	1.135	1.135	1.135
O	0.100	0.180		0.140	0.140	0.140	0.140	0.140
P	0.100	0.140		0.130	0.133	0.135	0.133	0.135
Q	0.240	0.260		0.250	0.250	0.250	0.250	0.250
R	0.677	0.697		0.692	0.683	0.683	0.684	0.684
S	0.100	0.140		0.128	0.125	0.123	0.130	0.130
T	1.565	1.585		1.575	1.575	1.575	1.575	1.575
U	0.540	0.560		0.553	0.552	0.555	0.550	0.551
V	0.912	0.932		0.926	0.926	0.925	0.924	0.925
W	0.787	0.807		0.797	0.795	0.797	0.795	0.797
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		0.504	0.504	0.505	0.506	0.505
AA	0.312	0.319		0.313	0.313	0.313	0.313	0.313
AB	0.990	1.010		1.000	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		0.502	0.506	0.501	0.505	0.503
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		0.237	0.237	0.237	0.237	0.237
AG	0.510	0.515		0.511	0.510	0.511	0.511	0.511
AH	0.100	0.120		0.110	0.110	0.110	0.110	0.110
AI								

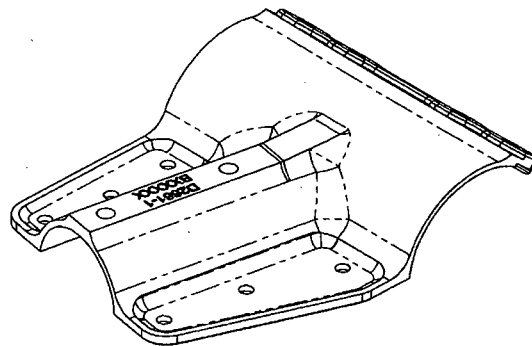
DART AEROSPACE LTD		Work Order:	79194
Description: 206 Saddle, Outboard, Right side		Part Number:	D2661-2
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 2 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

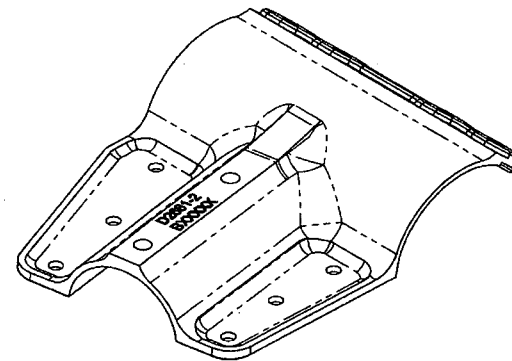
Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
AJ								
AK								
AL								
AM								
AN								
Accept/Reject								

Measured by:	<i>[Signature]</i>	Date:	12.02.05
Audited by:	<i>[Signature]</i>	Date:	12/03/05
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	<i>[Signature]</i>



D2661-1 SADDLE, OUTSIDE, LH



D2661-2 SADDLE, OUTSIDE, RH

SH- Y
 RE- Y
 UNCC- Y
 SUB- Y
 NO 79194
 M.C.S
 12/01/23

RELEASED
 2011-11-16

E	REDRAW & REFORMAT DWG: 0.687 WAS 0.547 (B6-2,B8-4), REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.318 WAS Ø0.313	CB	06.11.08
C	INCORPORATE DEO 9122, 9102, 9095	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	07.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	Q	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	R		
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.	1/10	D2661	SHEET 1 OF 5
APPROVED	1/10	TITLE	SCALE
DE APPR.	1/10	SADDLE, OUTSIDE	NTS
DATE	11.10.31	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

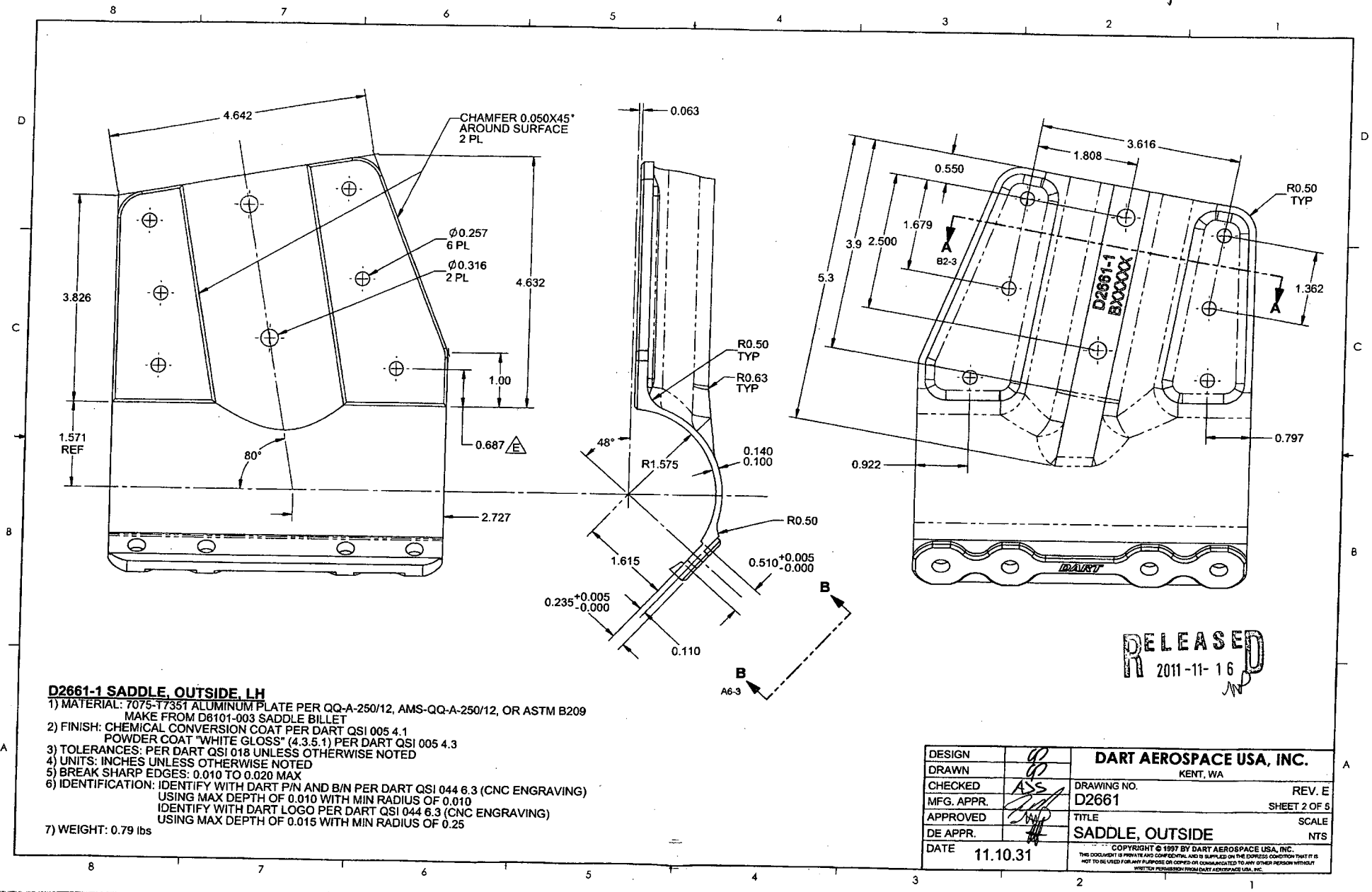
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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79194



RELEASED
2011-11-16

D2661-1 SADDLE, OUTSIDE, LH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D8101-003 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
- 7) WEIGHT: 0.79 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN	8	KENT, WA	
CHECKED	ASS	DRAWING NO.	D2661
MFG. APPR.		REV. E	
APPROVED		SHEET 2 OF 5	
DE APPR.		TITLE	SADDLE, OUTSIDE
DATE	11.10.31	SCALE	NTS
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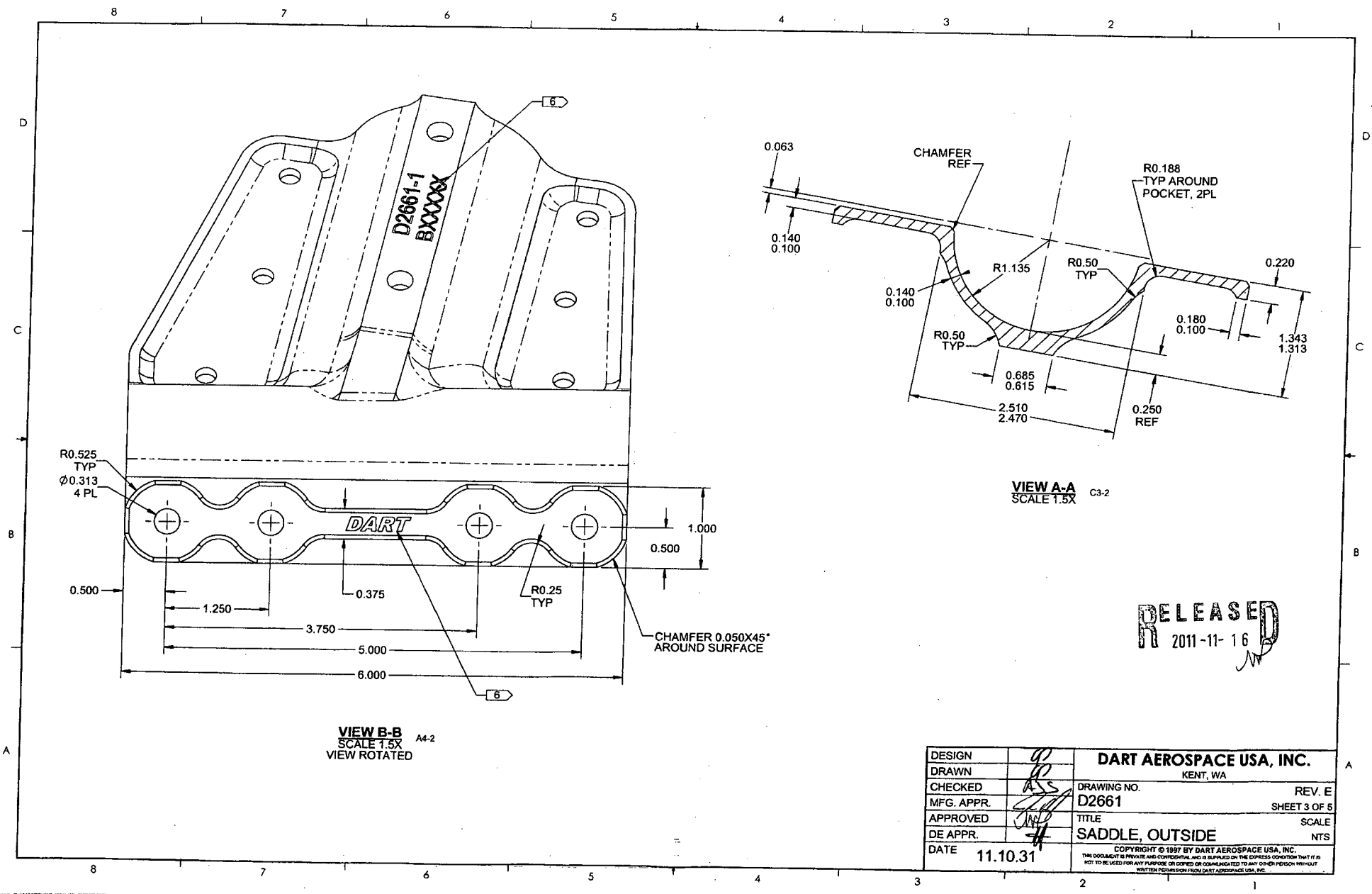
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RELEASED
2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2661	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, OUTSIDE	NTS
DATE	11.10.31	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

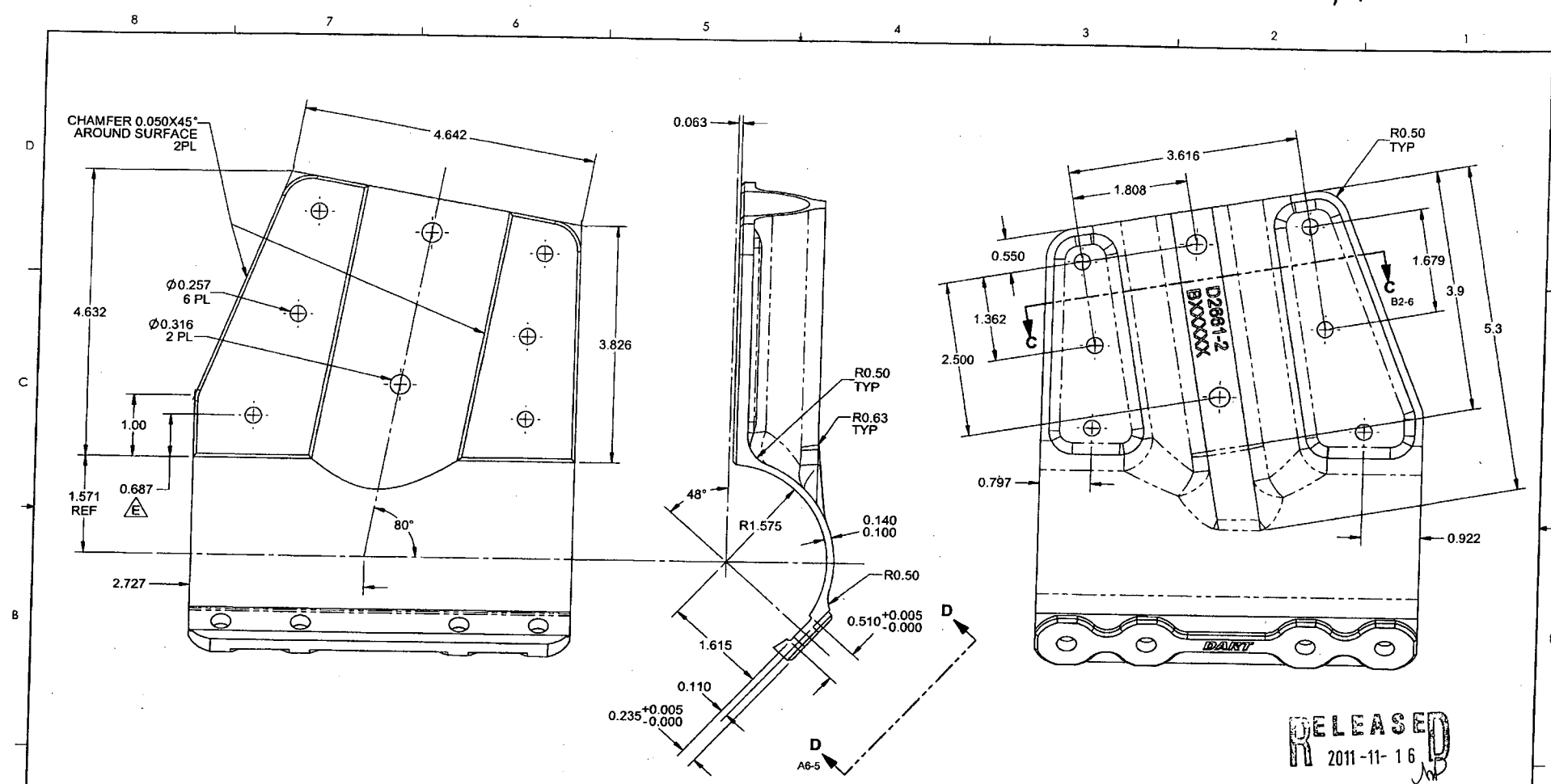
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79194



RELEASED
2011-11-16

D2661-2 SADDLE, OUTSIDE, RH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-003 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
- 7) WEIGHT: 0.79 lbs

DESIGN	g	DART AEROSPACE USA, INC.	
DRAWN	g	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.		D2661	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.	#	SADDLE, OUTSIDE	NTS
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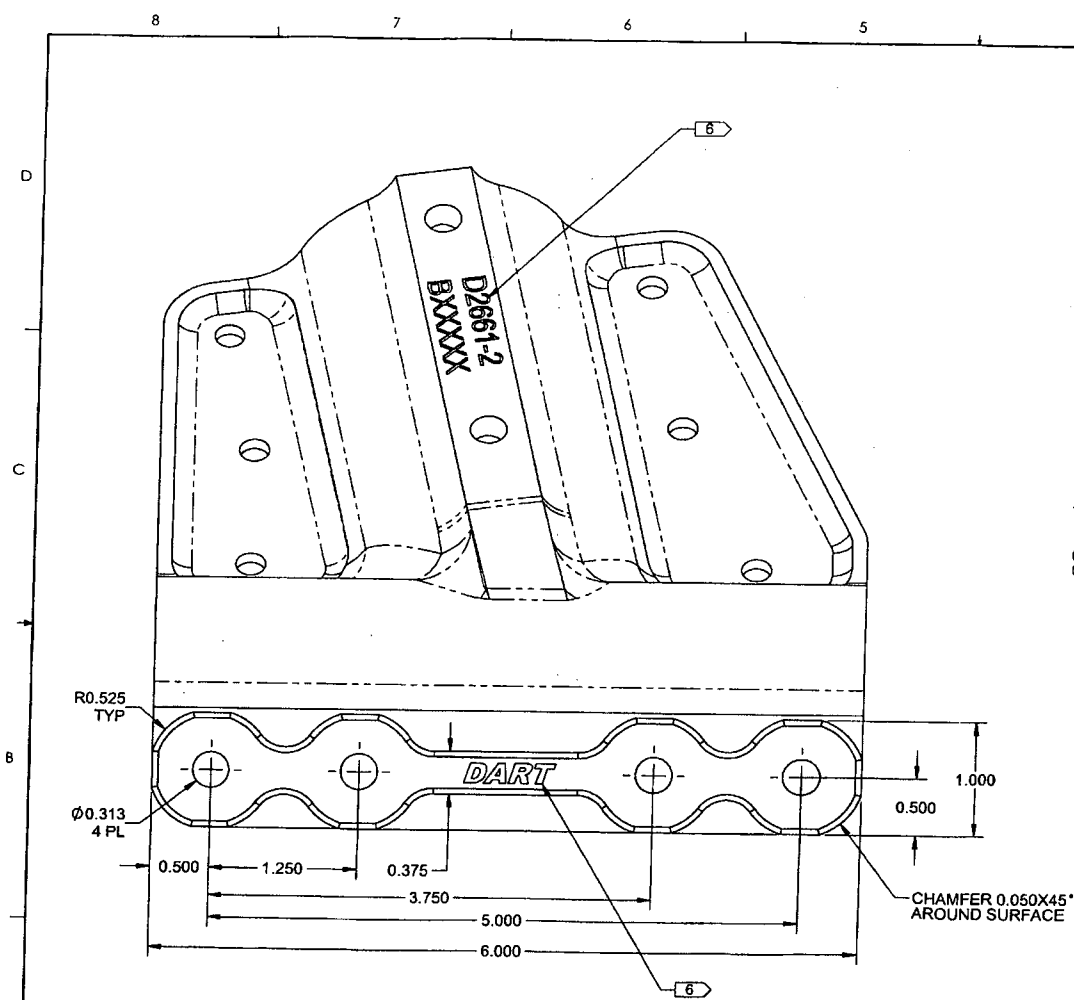
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

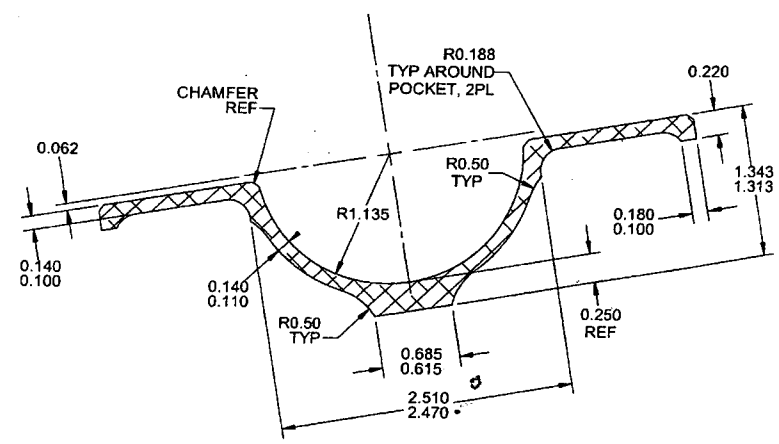
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

7194



VIEW D-D
SCALE 1.5X
VIEW ROTATED



SECTION C-C
SCALE 1.5X

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2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
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MFG. APPR.		TITLE	SHEET 5 OF 5
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries